

PRODUCT BULLETIN
GYPSUM PRODUCTS

5/8" SOFFIT BOARD
TYPE X

BULLETIN NO: B-44
DATE: 2/15/73
PAGE: 1 of 3

APPROVALS:

ASTM C 79

CANCELS: B-44
DATE: 11/17/72

back cut up PIF 4/11
PRODUCING PLANTS - Seattle

CORE FORMULA (lbs/MSF)

Board Stucco (S-1) 1650 - 1950

Paper Fiber (B-G-1) 0 - 15

Vermiculite Ore (RM-B-28) 22 - 25

Glass Fiber (B-G-1) 3.8 - 4.2

Starch (RM-B-11A) 9 - 12.5

Core Foaming Agent:

ALS or AAS (B-G-1) 0.2 - 1.7

Lignin (B-G-1) 3.5 - 4.5

End Trim (B-G-1) 0 - 35

Potassium Sulfate (B-G-1) 4.5 - 5.5
(in solution)

Retarder (B-G-1) 0 - 0.8

Hydrated Lime (RM-P-3) 0 - 0.5

Asphalt Wax Emulsion (RM-B-2A) 9 - 11
(gal/MSF)

NOTE: Rotate inventory of asphalt-wax emulsion. Do not use emulsion over 30 days old without pretesting. Potassium sulfate must be fed in a water solution.

PAPER LINERS

Grade No. 7018 Tan Soffit Board paper on both sides. (Bulletin RM-B-1A)

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OPERATING SPECIFICATIONS (Refer to Process Bulletin B-G-2 for General Specifications)

1. Slurry slump, inches 4-1/2 - 7
2. Slurry Setting Time, minutes 2 - 4-3/4
3. Wet Slurry Weight, lbs/cu. ft. 75 - 85
4. Wet Compressive Strength, psi 200 - 400
5. Moisture Content (take off prong type) 15 - 20%
6. Printing - Use nonbleeding ink for all printing on Soffit Board. Face printing shall read "KAISER GYPSUM SOFFIT BOARD - TYPE X".

PRODUCT SPECIFICATIONS (Refer to Product Bulletin B-G-4 for General Specifications and to Test Method Bulletins)

Wet Weight (lbs/MSF)	3200 - 3500
Dry Weight (lbs/MSF)	2100 - 2400
Evaporation Loss (lbs/MSF)	1000 - 1200
Thickness - Average (inch)	0.605 - 0.640
Edges	Tapered Edge
Edge Hardness at Take-off (lbs)	10 minimum
End Peel after Sawing (inch) (both leading and trailing ends)	1/8 maximum
Flexural Strength	
Across grain (lbs)	190 minimum
Parallel (lbs)	65 minimum
Deflection at Break, minimum	
Across grain (inch)	0.25
Parallel (inch)	0.15
Punch Test (lbs)	700 - 1100

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Product Specifications--Contd.

Twist Test, maximum split

Face (inch) 3/4
Back (inch) 3/4

Hammer Loss Test, decigrams

Individual Test, maximum 5.0

Bond at High Humidity, maximum peel

Face (inch) 1/2
Back (inch) 1/2

Water Immersion Test, 2 Hours

1 inch head of water at 70° F
Maximum weight gain (ASTM C 473) 10%

Surface Water Absorption, Face & Back

Cobb Test, 70° F water for 2 hours
(ASTM C 630)
Maximum weight gain 2 grams

NOTE: Do NQT use UL Bundling Tape on SOFFIT BOARD

Bundle two pieces face to face with Soffit Board Bundling Tape. Ship board using same loading methods, unit sizes and weather protection as 5/8" NULL-A-FIRE board.